



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3510

Job Sheet 179156



Part No: 646.3510

Job Qty: 12 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 7/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea			0.00	0.00	Start Up Waterjet		SC 8/16/15
110	Waterjet	12 pcs			0.00	0.47	Waterjet1		SC 18/10/15
120	QC	12 pcs			0.00	0.00	QC2 Waterjet-1		SC 18/10/15
130	QC	12 pcs			0.00	0.00	QC8-1		38
140	Small Fab	12 pcs			0.03	4.94	Small Fab-1		DX 18/09/10
150	QC	12 pcs			0.00	0.00	QC5		2-89
160	Large Fab	12 pcs			0.00	14.12	Large Fab 1		DX 18/09/10
170	QC	12 pcs			0.00	0.00	QC9		EL
180	QC	12 pcs			0.00	0.00	QC5		EL
220	SprayPaint	12 pcs			0.00	0.44	Spray Paint		DAS
230	QC	12 pcs			0.00	0.00	QC14		38
240	Packaging	12 pcs			0.00	0.00	Packaging3-1		DAS 9-89
250	QC21-SA	12 Ea			0.00	0.00	QC21		21 NOV 07 2018

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: *11/12* 2-Deburr if necessary
Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.

220 - Prime as per dwg (see note 3) Batch:

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

OCT 04 2018

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.3336 sf (.0278 ea)	90-Start up Operation	
M304TR0.500W.049	304 Round Tube .500 X .049W	9.9960 ft (.833 ea)	140-Small Fab	5092689

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	262	0
140-Small Fab	M304TR0.500W.049	10	117	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches ± 0.030	2.780 2.720	20755	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																				
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																				
Description Work Order Deviation By _____ Supervisor _____ Director _____ Part: 646.3510 Job No: 179156 Serial No/Batch: S081641 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/16/18 Container No: S081641 DART AEROSPACE Ltd. 1270 Aberdeen Street Hammerby, ON K8A 1K7 Canada TEL: 1-813-832-5200 Email: sales@dartaero.com www.dartaerospace.com																																																								
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2	Strut	1.500Inches ± 0.030	1.530 1.470	1,498
3	Strut	0.063Inches ± 0.010	0.073 0.053	0,058

Plex 6/14/18 10:55 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041263**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041263

PO Date: 10/4/18

Due Date: 10/5/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

E-MAILED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181381	646.3015	Blade 50 x	Firmed	-	OCT 09 2018	50 pcs	0 pcs	50 pcs	\$10.00/pcs	\$500.00
2	182625	647.4311	RH Lower Strut 10 x	Firmed	-	OCT 09 2018	10 pcs	0 pcs	10 pcs	\$10.00/pcs	\$100.00
3	181423	646.9711	Blade 120 x	Firmed	-	OCT 09 2018	120 pcs	0 pcs	120 pcs	\$10.00/pcs	\$1,200.00
4	179157	646.3511	Strut 12 x	Firmed	-	OCT 09 2018	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
5	179156	646.3510	Strut 12 x	Firmed	-	OCT 09 2018	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
Grand Total:											\$2,040.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/9/18 12:52 PM dart.lavoie.chantal

